

Date: Tuesday, 23/09/2008 10:22:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 42228		
Estimate Number	: 12564		
P.O. Number	:	Part Number	: D323815
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: D3238 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 33514	Material	:
Written By	:	Due Date	: 20/10/2008 Qty: 90 Um: Each
Checked & Approved By	: <u>JUD 08.9.23</u>		
Comment	: Est Rev:A New Issue 06-10-20 EC Est Rev:B Now on Waterjet 07-01-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S020	5052-H32 .020 Sheet
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Comment: Qty.: 0 sf(s)/Unit Total: 1 sf(s)

5052H32 aluminum sheet 0.020" thin

batch: 4894 B 8-10-7

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3238

Dwg Rev: CProg Rev: CB 8-10-7

2-Deburr if necessary

08/10/07 (96)(98)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-10-7

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counter
508/10/08 (96)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL08-10-08 (96)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 42228

Part Number: D323815

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(960)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. h 08/10/08

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/10/08 (96)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

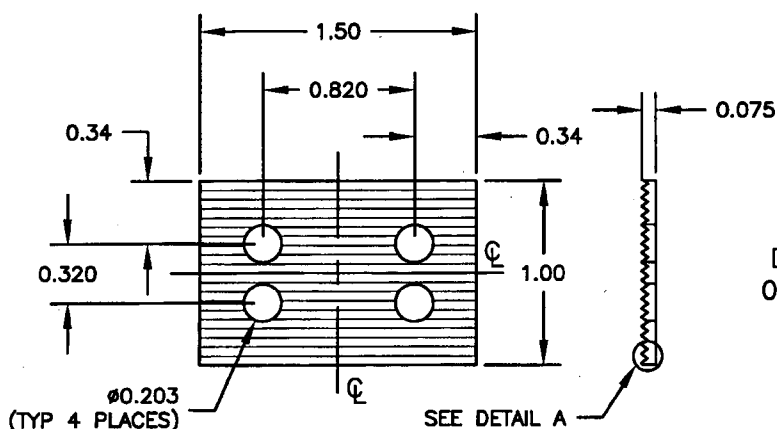
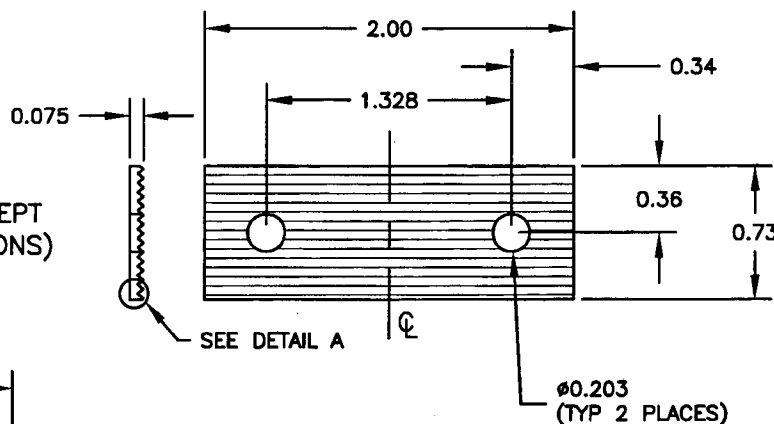


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

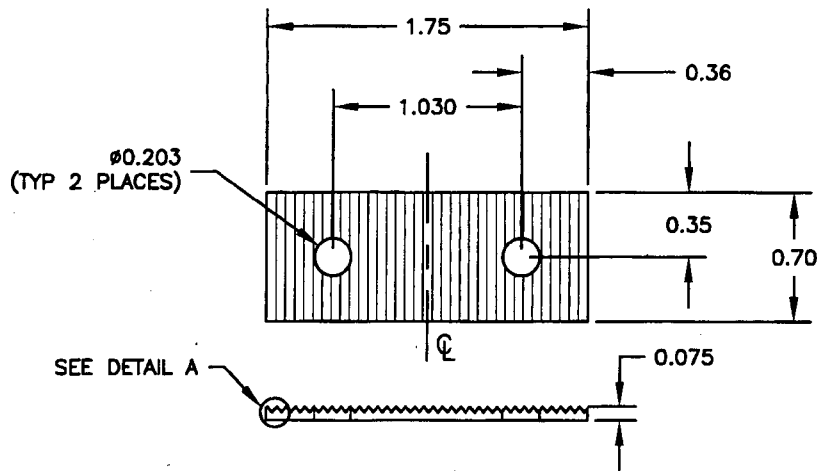
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NO. 42228

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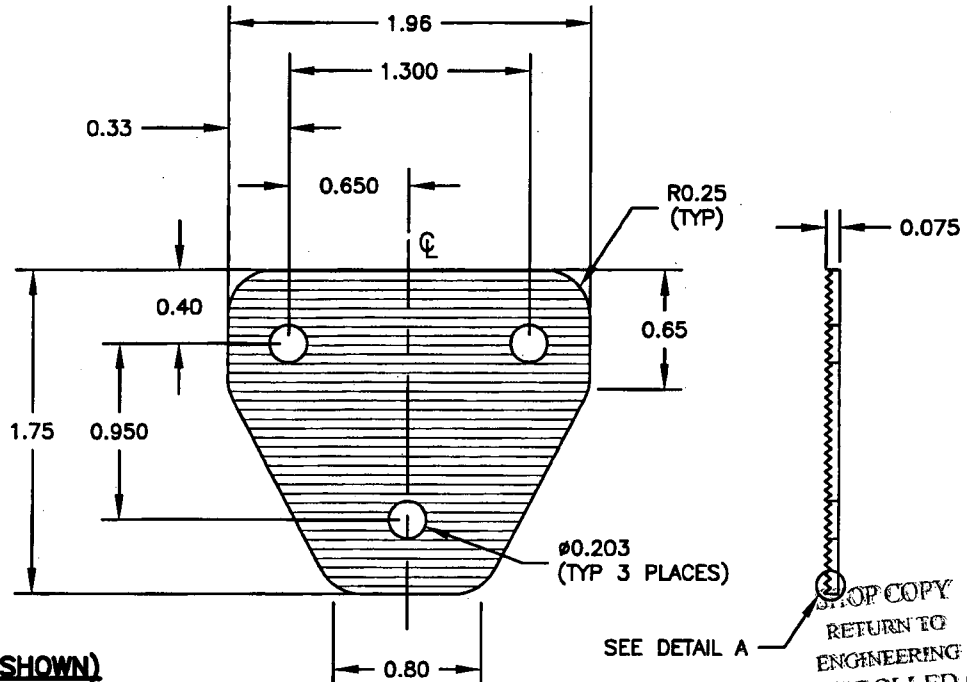
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

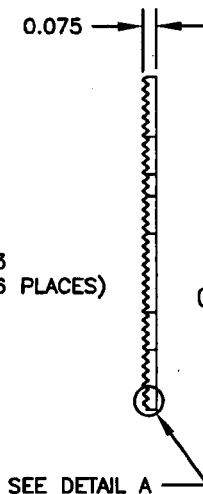
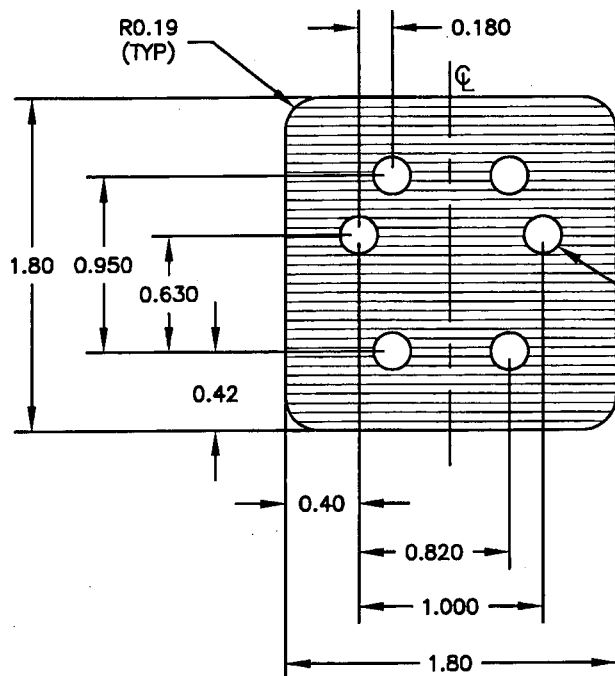
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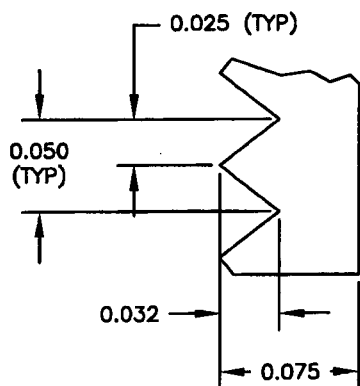
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DATE 07.02.19	TITLE PLATE		SCALE 1:1



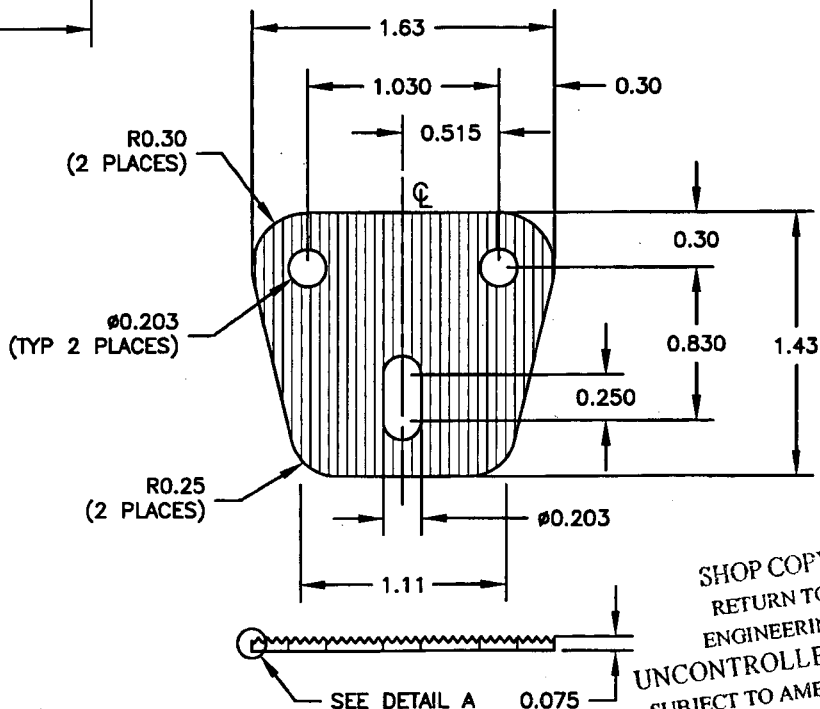
RELEASED

07.02.20

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT NO.
0.020 THICK AND NO SERRATIONS)

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